

# Work Order ID 57516

April 8, 2010 7:20:07 AM



Page 1

Item ID: D2648-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 4/08/10 Start Qty: 20.00



Cust Item ID:

Required Date: 4/15/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2648

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1010 .063

1-Cut as per Dwg D2648 \*\*\*\*\*CUT WITH FILE D2648-

1\*\*\*\*\* □Dwg Rev: D □Prog Rev: D

□

2-Deburr if necessary

MAT NOT pulled

AB 10-4-12

40

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

AB 10-4-12

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sublot 13

Locate  
40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57516

April 8, 2010 7:20:08 AM



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Item ID: D2648-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 4/08/10 Start Qty: 20.00



Cust Item ID:

Required Date: 4/15/10 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary <i>u/ps</i>								
140		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3								
150		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch <input type="checkbox"/> A/R 560 Hardcoat								
	<i>M1133X</i> 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary								

*SB 10/04/13*

*(40)*

*8*

*R*

*10-6-1*

*(X40)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 57516

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Item ID: D2648-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 4/08/10 Start Qty: 20.00



Cust Item ID:

Required Date: 4/15/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8-10-06-102

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8-10-06-102

10/06/10  
440

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:30 AM OVEN TEMPERATURE: 320°F  
FINISH TIME: 9:00 AM

⇒ 10/06/102

40

0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57516**

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Item ID: D2648-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 4/08/10 Start Qty: 20.00



Cust Item ID:

Required Date: 4/15/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

40 BR 10-6-3

200

Identify as per dwg &amp; Stock Location

FP-17

0.00



Packaging

Memo

0.00

Packaging

el 10/06/03

40-0

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/14 J  
C21016111

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 57516



Parent Item: D2648-3



Parent Item Name: Wearpad

Start Date: 4/08/10

Required Date: 4/15/10

Comments: IPP: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF  
IPP Rev:F Now on Waterjet 06-08-14 JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			100	sf	89.0000	1.5789	3.2		
											B10-4-12	
1010/1025 sheet 16GA												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT19

89

111410

89

105706

105706

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

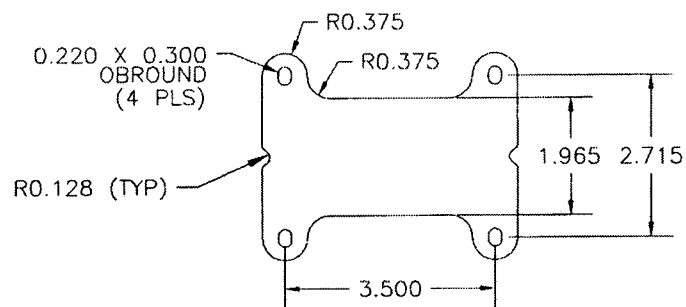
**NOTE:** Date & initial all entries



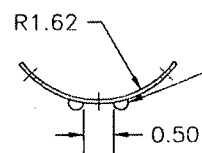


WLO 5756

# D2648-1 FLAT PATTERN

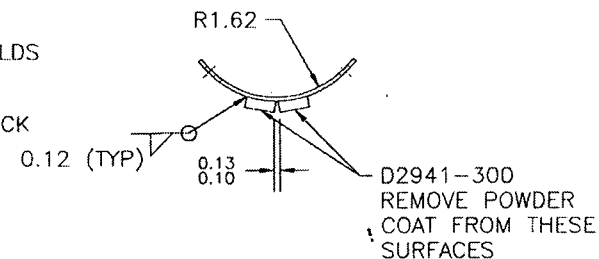


## SECTION A-A

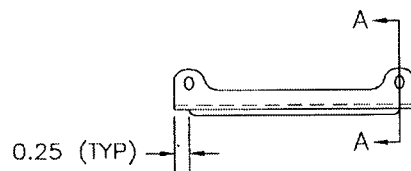


7560 HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.063 TO 0.125 THICK

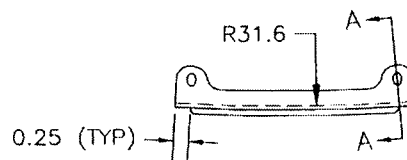
## SECTION B-B



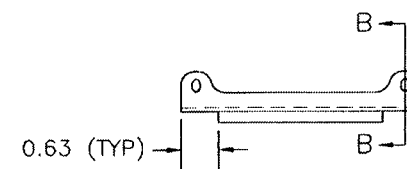
## D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED  
1997.12.20

BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BOLLEVILLE, MA
CHECKED	APPROVED	DRAWING NO. D2648
DATE		TITLE WEARPAD
99.11.17		REV. D SHEET 1 OF 1 SCALE 1:2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries